

1 **Abstract of the Disclosure**

2 This invention relates to foundry binder systems, which will cure in the presence of sulfur
3 dioxide and a free radical initiator, comprising (a) an epoxy resin; (b) an acrylate; (c) an
4 alkyl ester of a fatty acid, wherein the alkyl group of the ester is an aliphatic hydrocarbon
5 having from 4 to 8 carbon atoms, preferably butyl tallate; and (d) an effective amount of a
6 free radical initiator. The foundry binder systems are used for making foundry mixes. The
7 foundry mixes are used to make foundry shapes (such as cores and molds) which are used
8 to make metal castings, particularly ferrous castings.

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